Work Ord Növember-19-1.			· _ · · · _ · · · · · · · · · · · · · ·	*933	385*							Page 1	_
Item ID: Revision ID: Item Name: Start Date:	647.7918 Bracket 11/15/12	Start Qty: 3.00	*3*	Accept	*N900		1100	ገ*	Setup S	Start Stop	*N *N	S1* S2*	
Required Date		Req'd Qty: 3.00	*3*		Customer:	•			٠				
Reference: Approvals:	Process Pl	an: <u>M</u> LJ	Date: \7 - 1 -			Pate:				Start Stop		R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Tumber	Insp. Stamp	_
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110 Waterjet FLOW CNC Water 2024 .0	· .	Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_	N/C	0.00				3	0		,	Jm12-11-	-25
		2-Deburr if	necessary										
120		QC2- Inspect parts off n	nachine FAI/FAIB	0.00									
120		Memo	\	0.00				_3_	Ĉ	<u> </u>		Jm 12-11-	25

Quality Control

									,		DQA:	Date:	
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Work Orde Part N NCR N	o						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Desc	•	tion of work order update r Non-conformance		nitial ief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Landin	general Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat General Bend Bend BoM/Route Broken/Damaged Burrs Contamination Countersink						Bend BOM/Route Broken/Damaged Burrs Contamination		instruct Mainte	ion Incomplete ions Incomplete/Unclear enance	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Countersink Cut Too Short Drill Holes Drawing Finish						Cut Too Short Drill Holes Drawing		4 .	 	Positioned W Power Loss/S		Other

Outside Dimensions

Wave/Twist in Tube

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Work Ord				*933	85*							Page 2
tem ID: Revision ID:	647.7918			Accept	*N900	040	100)*	Setup S		*N.S	
tem Name: tart Date: Required Date: Reference:	Bracket 11/15/12 : 12/07/12	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:					*NS	57"
Approvals:		n:				ate:				Ston	*NF	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours AS	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec Qty		eject umber	Insp. Stamp
30 *130* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00]2]] (3				.•
⁴⁰ *1 ⊿∩ *		Form as per dwg		0.00				3				S) 13(
Brake NC		Memo		0.00	.*							
150		QC5- Inspect part comp	leteness to step on W/O	0.00 AS				3				
QC		Memo		0.00 12)	γ							

Quality Control

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Part			·				Rework Scrap Use-as-is			Machining S	Crosstube Small Fab Finishing	4	Water Jet I. Eng. Coor. e/Packaging	Engineering Quality Other
NCR	No.						Work Order Update			Large Fab Co	omposite		Supplier	
Root					Descr	rip	tion of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		01	r Non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
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		Cracks				ال	Broken/Damaged		Inspecti	on Incomplete		Part Incorrec	t	Weld
		Crushed/C	Crimped,		L	_	Burrs		Instruct	ions Incomplete/Uncle	ear	Part Lost/Mis	ssing	Wrong Stock Pulled
		Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			_]	Countersink		Mislabe	led		Positioned W	rong	_
		Inspection	Strip in	Tube		_]	Cut Too Short		Misread	l		Power Loss/S	Gurge	Other
•		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusior	۱ [Drawing		Out of (Calibration				
		Turning Se	equence				Finish		Out of S	equence				
	Wave/Twist in Tube Folio								Outside	Dimensions	*			

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Work Orde				*9338	35*						Page 3	
Revision ID:	647.7918			Accept	*N900	040	100)* s	etup St	1 1	IS1* IS2*	
Item Name: Start Date: Required Date: Reference:	Bracket 11/15/12 12/07/12	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:				IX	10/	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		nte:		R		tart *N	IR1* IR2*	
Sequence ID/ Work Center II 160 *160* Outsource4 Outsource process -		Operation Description Outsource process-Anodi Memo ISSUE P/O: HARD ANO		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Insp. r Stamp	
170 *170* Packaging Packaging		Receive & Inspect for Da	amage & Mat'l Certs	0.00				3x_			13-4-1	S
180		QC5- Inspect part comple	eteness to step on W/O	0.00				4				

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Quality Control

Memo

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	AANCE / UP	DATE	01.01	Data	
												QA Closed:	Date:	
Work Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR	No.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Root Cause		Date	Step	Qty	Des		otion of work order update or Non-conformance	1	nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
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	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on incomplete ions incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning Sequence								Out of S	equence				

Outside Dimensions

Wave/Twist in Tube

Work Orde <i>November-19-12</i>				*933	385*							Page 4	ļ
Item ID: Revision ID:	647.7918			Accept	*N900	040	100	* 5	Setup S		*NS	31*	
Item Name:	Bracket								3	top ;	*NS	ミン*	
Start Date:	11/15/12	Start Qty: 3.00	*3*		Cust Item I	D:							
Required Date:	12/07/12	Req'd Qty: 3.00	*3*		Customer:								
Reference:							_	· T	Run S	tart :		- 4 de	
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ıte:		Г			"NH	₹1*	
• •	QC: _,		Date:	SPC (Y/N):	Da	ite:			S	stop	*NF	₹2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty			Insp. Stamp	,
100 SprayPaint Spray Painting		Memo PRIME IAV	V MIL-P-23377J TYPE	0.00 1 CLASS N AS PER DWG.	(SEE NOTE 2)				Ø		ø	13-5-	H
		CARDINAL	_ 4860-50 PRIMER BA	тсн: 12<i>5452</i>									
²⁰⁰ *200*		QC14- Inspect Spray Pa	int	0.00 AS 16 16	13/05/16		Ó	(S)					
QC Quality Control		Мето		0.00									
210		Identify as per dwg & St	cock Location: 13 §	0.00		(/	1 2	16/0	17	(2)		

710
Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

NCR:	Yes	/ No				WORK ORDER NON-O	100	VFOR	MANCE / UP	DATE			•
											QA Closed:	Date	:
Work Ord	er: _					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part I	_					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	┥.	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	-				Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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	Torque Waves in Extrusion					Drawing		Out of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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Work Orden				*933	885*							Page 5
Item ID: Revision ID: Item Name:	647.7918 Bracket			Accept	*N900	040	100)*	Setup	Start Stop	*NS	•
Start Date: Required Date: Reference:	11/15/12 12/07/12	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NR	?1* ?2*
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	•	nsp. Stamp
220 QC Quality Control		Мето		0.00						MI	5 13	05-17

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE			•
											QA Closed:	Date:	•
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		i .	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	/Data							T.CATE					
							AUL	T CATE	GORY				
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	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs				Bend BOM/Route Broken/Damaged Burrs Contamination		1	ion Incomplete ions Incomplete/	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
1	Heat Treat					Countersink	Г	Mislabe	eled		Positioned V	Vrong	

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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Picklist Print

November-19-12 9:25:20 AM

Work Order ID:

93385

Parent Item:

647.7918

Parent Item Name:

Bracket

Start Date: 11/15/12

Required Date: 12/07/12

Page 1

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			110	sf	239.7200	0.163	0. 51 47368 			Jmn
•				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT022		239.72							
				1199	916	0.1							
				1211	197	12.32			-(2.0				
				1236	554	35.3			J23	% 54			
				1237	701	192			·				

DQA:	Date:	
-		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

TTCH.		, 110									QA Closed:	Date:	•
Nork Ord	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part I	,					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No.	.				Use-as-is Work Order Update]	Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root-				,	Descr	iption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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	<u> </u>	Bending	_		_ ,_	Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced
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	┝	Cracks	- · ·		_	Broken/Damaged	-	1	on Incomplete	(14 - 14 - 1	Part Incorred		Weld Wrong Stock Pulled
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	-	Turning Se			" ├	Finish	-	ł	Sequence				
		I milling 3	quence	oe .	⊢	Folio	—	Outside	•				

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NOTES:

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MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4

FINISH: ANODIZE PER MIL STD-A-8625, TYPEIII, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377 J TYPE I CLASS N

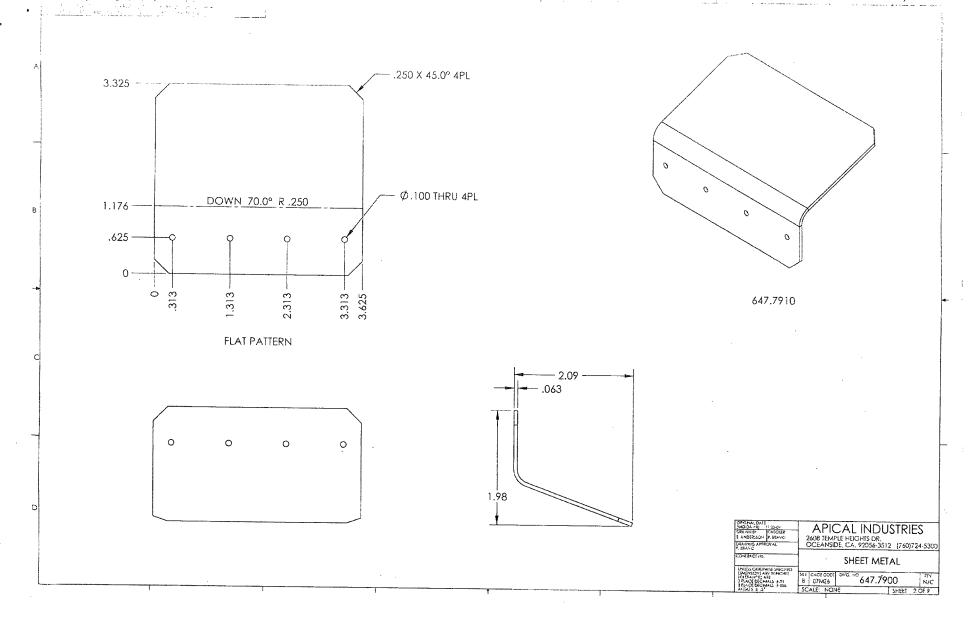
3. DEBURR AND BREAK ALL SHARP EDGES

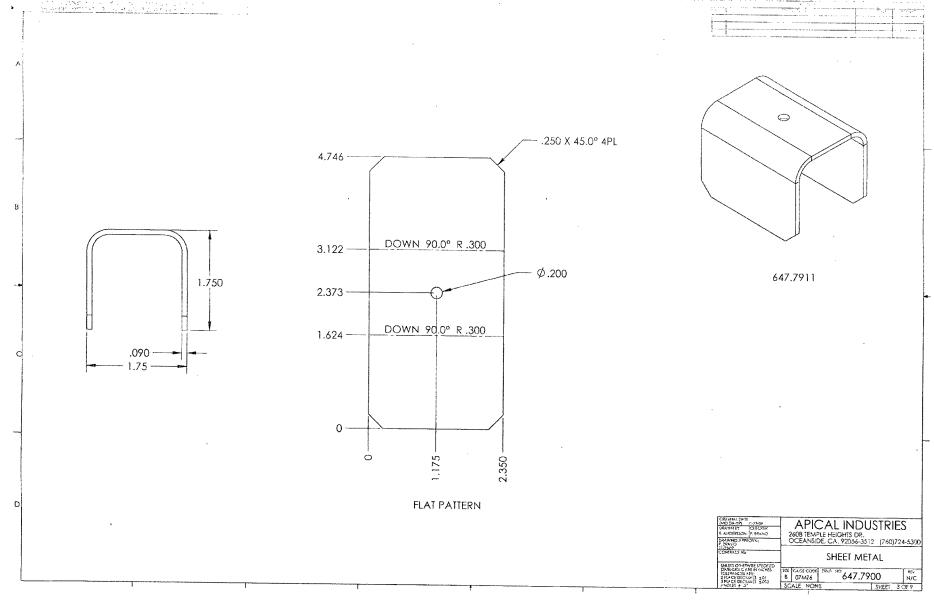
4. IDENTIFY IAW MPP-120

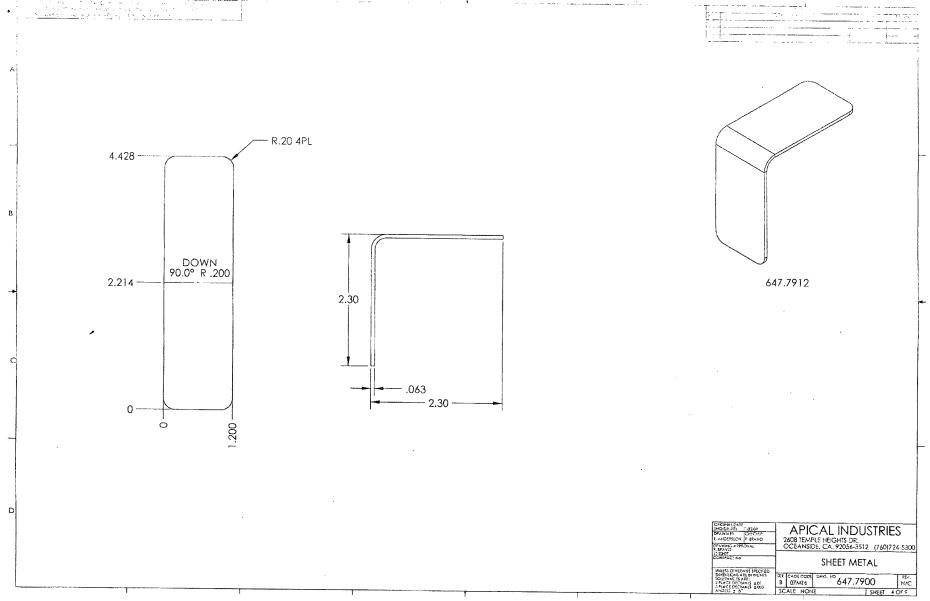
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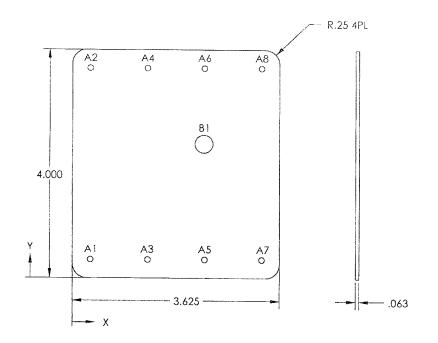
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	11/23-76 11) CONCRACTING UNICOS CONEPASTS SPECIFIC			SHEET METAL	
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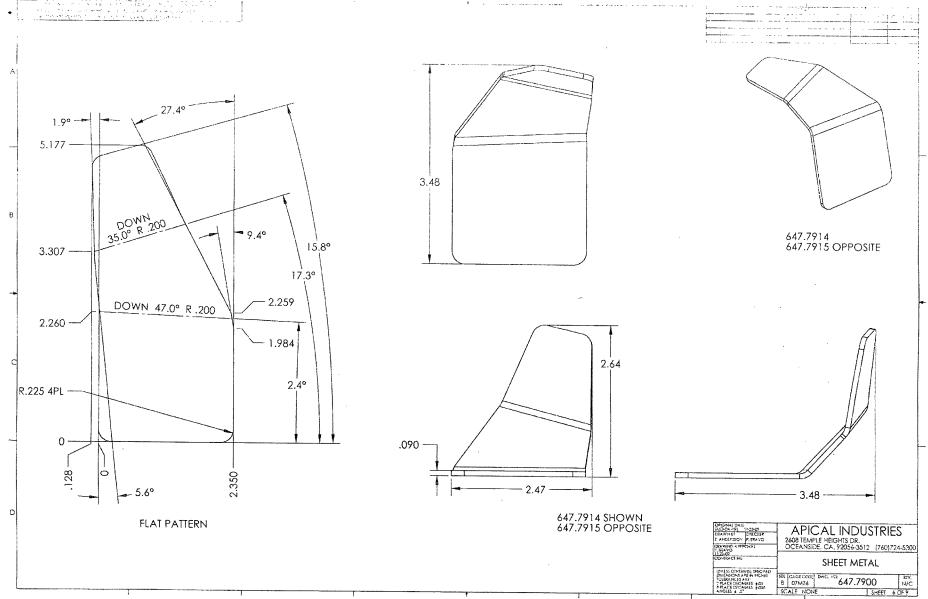


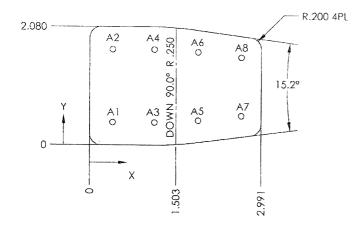
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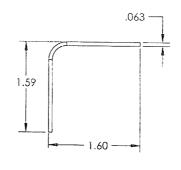
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A2	.313±.002	3.675±.002	Ø.100
A3	1.313±.002	.325±,002	Ø.100
A4	1.313±.002	3.675±.002	Ø.100
A5	2.313±.002	,325±.002	Ø.100
A6	2.313±.002	3.675±.002	Ø.100
A7	3.313±.002	.325±,002	Ø.100
8A	3,313±.002	3.675±.002	Ø .100
В1	2.300±.002	2.350±.002	Ø.313

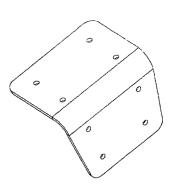
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OPGELL GATE IMG DA-19] 11-20-09 DPAWREY CHECKER E. AMDERSON P BRAVO	2608 TEMPLE HEIGH	
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COMPACT No	SHEE	T METAL
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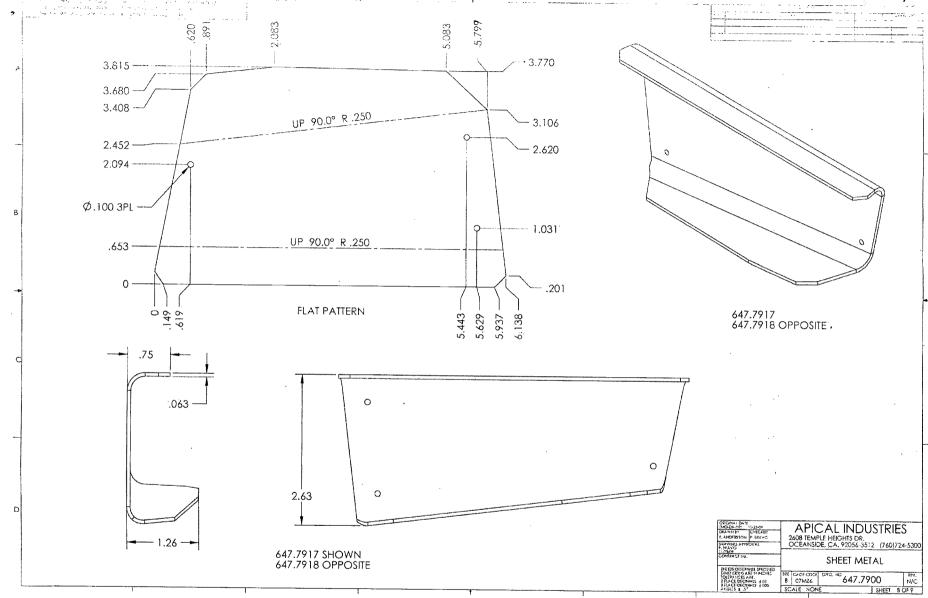
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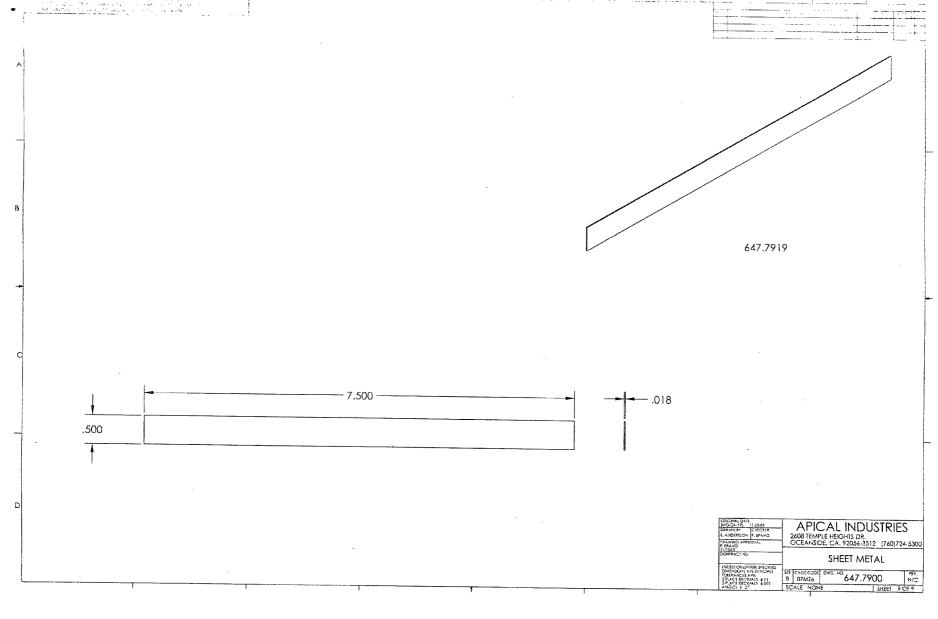
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A2	.400±.002	1.680±.002	Ø.100 THRU
A3	1.125±,002	.400±.002	Ø.100 THRU
A4	1.125±.002	1.680±.002	Ø.100 THRU
A5	1.891±.002	.440±,002	Ø.100 1HRU
A6	1.891±.002	1.640±.002	Ø.100 THRU
A7	2.646±,002	.528±.002	Ø.109 THRU
A8	2.646±,002	1.553±.002	Ø.100 THRU

DRGRAI DATE MCDAYES :1-23-07 DRAWHES CHECKER E. ANDERSON P. BRAVO DRAWEG APPEDVAL E. BRAVO	APICAL INDUS 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512	
CONTRACT HS	SHEET META	۸L
TREESS OFFERWARE SPECIFED DARFITSONS ARE SO SWCHES SCREAMED AND A SPECIFIC DECREASES AND A PLACE DECREASE AND A PLACE	B 07M26 DWG. NO. 647.790	0 R7V.
ANGLES a 5"	SCALE NONE	SHEET 7 OF 9

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DART AEROSPACE LTD	Work Order:	93365
Description: Bracket	Part Number:	647. 6918
Increasion Duras / dec std Daniel		
Inspection Dwg: 647,7900 Rev: N/c		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	+0.00	Dimension			Inspection	
\$0.100°	0, -0001.	0.100			V	Producer
2.094"	41- 0 ves	2.094			- V	
3406"	H- 0.005	3. 408-			· V	
3.680"	41-0.005"	3.6600	~		V	
3.815"	4-0.005	3.85"	_		V	
0.620"	4-0.005	0.600	-		V	
0.891	-11-0005	0.891"			V	
2.083	4-0.005"	7.083			V	
5.083"	H-01005	5.0831	_		· V	
5.399"	H-0:05	5.780	_		V	ş 4 .
3.770"	t1-01.005°	3.772"	ىق		V	
3.106"	A-0005"	3106	_		V	
2 620"	H- 3.005"	3.622	- ,	a.	V .	
1.031	4-0,005	1.033	_		V	
0,20,"	40005	0.201	_		V	
0.1491	16000	0.149"				
0.619'	#-0001	0.6g"	_	·	U	•
5,443	4-0005	5.443	-		V	
5,629"	11-0005	5,629"	-	,	V	
5.937"	4-0005	5,539**	_		V	
6.138	11-0005	Co. 135"	-		·	
0.063	4-0.00	6.062"	1.2		V	
		No.				
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Measured by:	Jm
Date:	12-11-25

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Audited by:		15	
Date:	1)	1126	

Preliminary Approval:	
Date:	



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62282

Date: 26-Mar-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-52	200 Fax: 613-632-1185	Ph	: 613-632-5200	Fax: 613-632-1185	
Terms		Ship Via			
Quantity	Description				
1 lot	Part: ASST 3 PCS 647.7918 3 PCS 647.1814 3 PCS 647.7917 4 PCS 41232-200-002-001 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 24 PCS D2348 20 PCS D2428 8 PCS D4726-1 20 PCS D2056 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 8 PCS D3299-7 BLUE ANODIZE MIL-A-8625 TYPE II CLASS 2		Rev:		
	Job: 20130177 — Certificate of Con	PO: 19404	Line:		
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: 26/3//3 CERTIFIED SIGNATURE: CERTIFIED SIGNATURE:				
	RECEIVER SIGNATURE :				